April-11-13 7:46:44 AM

Item ID: Revision ID:	D4130-5			Accept	*N90	0040	100)*	Setup Star	^t *N	S1*
Item Name:	Fwd Cargo F	Floor Protector						•	Stop	*N	S2*
Start Date: Required Date: Reference:	4/11/13 4/25/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Iter Custome					1 4	
Approvals:	Process Pi	lan: _ MLJ	Date: 13-04-	// Tooling:		Date:			Run Star	171	R1*
		· · · · · · · · · · · · · · · · · ·		•		Date:			Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	vision Nbr			1,				·	. — — .	
D4130	В										
100				0.00							
100		FLOW WATER JET						Ø	\mathcal{A}	13-6	-10
Waterjet		Memo		0.00						·	
FLOW CNC Waterje		1-Cut as per Dwg Rev:_ Prog Rev:_ 2-Deburr if	B								
110		QC2- Inspect parts off m	achine FAI/FAIR	0.00							* .
*11 0 *		Cara and the burne on in		0.00					_	17-6-19	
QC		Memo		0.00				0		1-6-19	<u> </u>
Quality Control											
120		QC8- Inspect parts - seco	and check	0.00			•				
120 QC Quality Control		Memo		0.00 B	o ll			J			-

NCR: \	es / No				WORK ORDER NON-	COL	NFORM	MANCE / UP	DATE			
										QA Closed:	Date	:
Work Orde	er:				DISPOSITION		•		AGAINST DE	PARTMENT	/PROCESS	
					Rework	7		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	No.				Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No				Work Order Update]		Large Fab	Composite	J	Supplier	
Root				Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data											·	
Equip/Tooling												
Operator												
Material								1				
Setup		ł										
Other		!										
Process	\square											
Supplier	\dashv	1										
Training												
Unapproved		<u> </u>	<u>i </u>			ALIE	T CATE	GORY				1
Landi	ng Gear				General	AUL	CAIL	JOK1				
Laria	Bending				Bend		Grain			Ovalized	Γ	Pressure/Forced
	Centre N	ot Conce	ntric to	0/5	BOM/Route	\vdash	Hardwa	ire	<u> </u>	Over/Under	tolerance	Temperature/Cure
	Cracks	or conce	meric to	~~ 	Broken/Damaged	\vdash	ł	ion Incomplete		Part Incorre	-	Weld
	Crushed/	'Crimped			Burrs	-	1	tions Incomplete/l	Unclear	Part Lost/Mi) —	Wrong Stock Pulled
	Cuffs				Contamination	Н	Mainte	•		Part Moved	~ <u>L</u>	
	Heat Tre	at			Countersink		Mislabe			Positioned V	Vrong	
	Inspection		Tube		Cut Too Short	\vdash	Misread		<u> </u>	Power Loss/	_	Other
	Ripples in	•			Drill Holes		Offset			_	<u> </u>	
	Torque V		Extrusio	,	Drawing		Out of (Calibration			i ••• ···	

Out of Sequence

Outside Dimensions

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-11-13 7:46:44 AM

Revision ID:	D4130-5			Accept	*N900	<u>040</u>	100)* s	etup Sta	I ZI	S1*	
Item Name:	Fwd Cargo F	loor Protector							Sto	$^{\rm p}$ *N	S2*	
Start Date:	4/11/13	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date:	4/25/13	Req'd Qty: 1.00	*1*		Customer:		4			,		
Reference:			. •				•					
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:		R	un Sta	1/1	R1*	
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
130		Identify as per dwg & Sto	ock Location:	0.00				- •		1	1	
130 Packaging		Memo	Pp 199516	0.00				(0/3	16/11		
Packaging												
140		QC21- Final Inspection -	Work Order Release	0.00								
*14 0 *		Memo		0.00				/h	(J 1)	3-06-1	12	
Quality Control												

MB-04-12

NCR:	⁄es	/ No				WORK ORDER NON-	·CO	NFORM	MANCE / UPDATE			_		
,								T			QA Closed:	Da	ite:	
Work Orde	er: _					DISPOSITION	¬				PARTMENT,	/PROCESS Water Jet		Engineering
Part N	•					Rework Scrap Use-as-is		Thern	Machining Sm noforming Fi	sstube nall Fab nishing		d. Eng. Coor. re/Packaging		Quality Other
NCR N	۷o.					Work Order Update			Large Fab Com	nposite		Supplier		
Root Cause		Date	Step	Qty		ption of work order update or Non-conformance	- 1	Initial nief Eng	Action Description		Sign & Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
							FAUI	LT CATE	GORY					
Landi		ì				General		7			1			
		Bending Centre No Cracks Crushed/			o/s	Bend BOM/Route Broken/Damaged Burrs		Instruct	on Incomplete ions Incomplete/Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi	ct		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Cuffs Heat Trea Inspectio		Tube		Contamination Countersink Cut Too Short		Mainte Mislabe Misread	led		Part Moved Positioned V Power Loss/	•		Other
		Ripples ir Torque V		Extrusio	n	Drill Holes Drawing		Offset Out of 0	Calibration					

Out of Sequence

Outside Dimensions

DQA: _____

Date: __

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-11-13 7:46:47 AM

Work Order ID: 99517

99517

Parent Item:

D4130-5

D4130-5

Parent Item Name: Fwd Cargo Floor Protector

Start Date: 4/11/13

Required Date: 4/25/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 10.06.08 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Dar Issued Issu		Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,058.404	5.9414	6.254105			
*MIFXS 1	25-F60	N29-N4	*						**	EZ	13-6-1	٥	

MLEXS 125-F60029-04

GE PLASTICS LEXAN SHEET

Location Loc Code Loc Qty MAT018 2058.404

124654 394.404 124866 1664

9.31

Page 1

												DQA:	Da	ate:	
NCR:	⁄es	/ No				WORK ORDER NON- 0	0	NFORM	MANCE / UP	DATE		·	<u>.</u>		
									-			QA Closed:	Da	ite:	
Work Orde	er:					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Part N	•					Rework Scrap Use-as-is		ı	Skid-tube Machining moforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR I	No.					Work Order Update]		Large Fab	Composite]	·	Supplier		
Root					Descri	ption of work order update		Initial	Ac [,]	tion	T	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	\perp	Date	Verificatio	n	QC Inspector
Doc/Data			-												
Equip/Tooling															•
Operator															
Material											1	·			
Setup							Ì				-				
Other															
Process															
Supplier															
Training							1		ĺ						
Unapproved															
						F	AUL	T CATE	GORY						
Landi	ng (ear				General		_						_	-
		Bending				Bend		Grain			╛	Ovalized		L	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete			Part Incorrec	t		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	ıt			Countersink		Mislabe	eled			Positioned W	/rong		<u>.</u>
		Inspectio	n Strip in	Tube	<u> </u>	Cut Too Short		Misread	1		٦	Power Loss/S	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

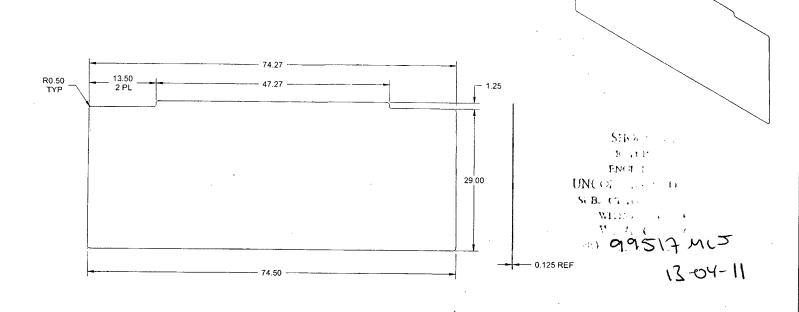
DART AEROSPACE LTD	Work Order:	99577
Description: Fwd Cargo Floor Protector	Part Number:	D4130-5
Inspection Dwg: D4130 Rev: B	,	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.50	+/-0.030	17.5	~		1 JK	MUG
46.25	+/-0.030	46.25	~		10	
0.125	+/-0.010	0.125			4	
						·
	· _					
				i		

	O A.e	
Measured by:	Audited by: 27	Preliminary Approval:
Date: /3.6/0	Date: 13 6 11	Date:

Rev	Date	Change	Revise	ed by	Approved
Α	10.10.25	New Issue	KJ		
В	12.05.15	Dwg Rev updated	KJ	4	//1//
				1/1	the feet for



D4130-1 FWD CABIN FLOOR PROTECTOR (TEXTURED SIDE SHOWN)

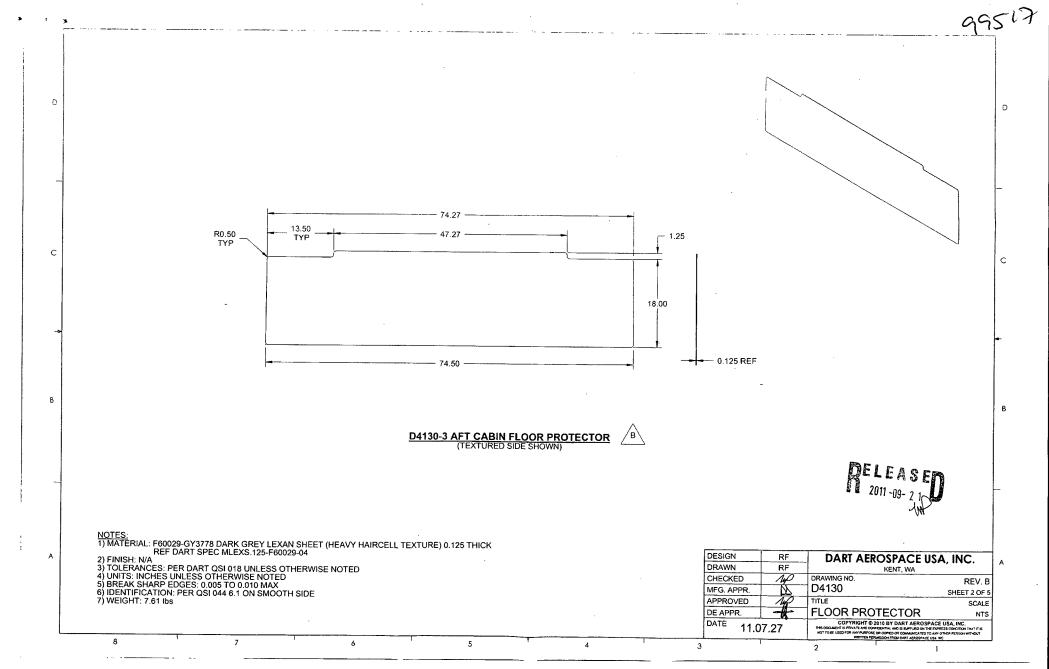
NOTES:
1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1 ON SMOOTH SIDE

7) WEIGHT: 12.07 lbs

ADD D4130-1/-3 (ZN B4-1 & B4-2) RF 11.07,27 Α NEW ISSUE RF 10.09.16 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE USA, INC. DRAWN RF KENT, WA CHECKED DRAWING NO. REV. B D4130 MFG. APPR. SHEET 1 OF 5 APPROVED SCALE FLOOR PROTECTOR DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.

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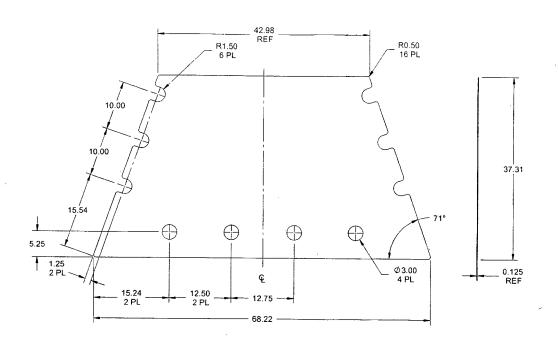


D С 17.50 R0.50 - 0.125 REF 46.25 TYP <u>D4130-5 FWD CARGO FLOOR PROTECTOR</u> (TEXTURED SIDE SHOWN)

NOTES:
1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1 ON SMOOTH SIDE
7) WEIGHT: 4.41 lbs

DESIGN HS		DART AEROSPACE US	A. INC.
DRAWN	ŔF	KENT, WA	. , ,
CHECKED	140	DRAWING NO	REV. B
MFG. APPR.	<i>y</i>	D4130	SHEET 3 OF 5
APPROVED	MPs	TITLE	SCALE
DE APPR.	-#	FLOOR PROTECTOR	NTS
DATE 11.0	7.27	COPYRIGHT © 2010 BY DART AEROSPA THIS DOCUMENT IS PRIVATE AND COMMERCIAL AND IS SUPPLIED ON THE E NOT TO BE USED FOR MAY PURPOSE OR COPPED OR COMMUNICATED TO A	SUPPLESS CONOTION THAT IT IS NOT OTHER PERSON WITHOUT



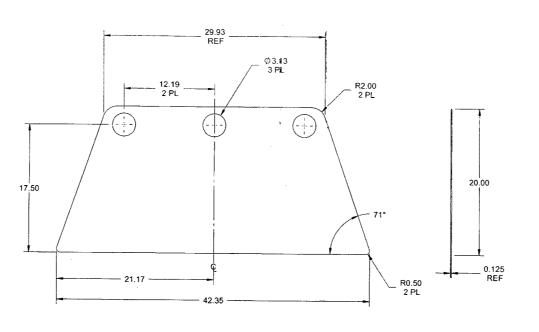
0

<u>D4130-7 CENTER CARGO FLOOR PROTECTOR</u> (TEXTURED SIDE SHOWN)

NOTES:
1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04

REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1 ON SMOOTH SIDE
7) WEIGHT: 10.92 lbs

DESIGN	HS	DART AEROSPACE USA, INC.					
DRAWN	RF						
CHECKED	140	DRAWING NO.	REV. B				
MFG. APPR.	\mathcal{P}	□ D4130	SHEET 4 OF				
APPROVED	NA	TITLE	SCALE				
DE APPR.	-4-	FLOOR PROTECTOR	NTS				
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D4130-9 AFT CARGO FLOOR PROTECTOR (TEXTURED SIDE SHOWN)

NOTES:
1) MATERIAL: F60029-GY3778 DARK GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04

REF DART SPEC MLEXS.125-F60029-04
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1 ON SMOOTH SIDE
7) WEIGHT: 3.78 lbs

DESIGN	HS	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	Nef	DRAWING NO.	REV. B
MFG. APPR.	<u> </u>	D4130	SHEET 5 OF 5
APPROVED	NP	TITLE	SCALE
DE APPR.	-#-	FLOOR PROTECTOR	NTS
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